

Work Order ID 77052

November-25-11 8:31:33 AM


77052

Page 1

Item ID: D2877 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Spacer
 Start Date: 25/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2877	Rev B								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2877 Dwg Rev: B Prog Rev: B 2-
6061, 1250 deburr B11-12-14 

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control B11-12-14

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 5/11/2/16 count 450

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

50 of 260 u(12/11
courtesy

50X of M-1 11/12/16

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>25</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11-12-20
(50)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D2877

D2877

Parent Item Name: Saddle Spacer

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP B 00.05.19 Added inspect level 8EC
IPP C 06.04.26 Water jet EC
IPP Rev:D Now M6061-T6 06-06-23 JLM
IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			110	sf	84.7400	0.0607	2.555789	3.		

M6061T6S 125

6061-T6 .125 Sheet

**

B11-12-14

Location	Loc Qty	Loc Code
MAT009	4.9	
119513	4.9	
MAT021	79.84	
113608	65.35	
118217	14.49	

113608

10

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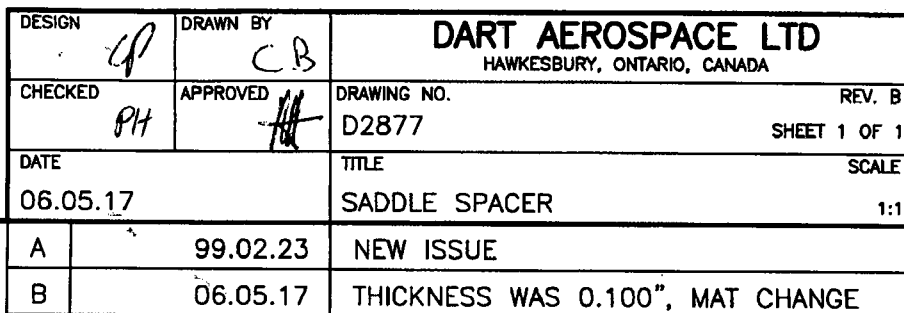
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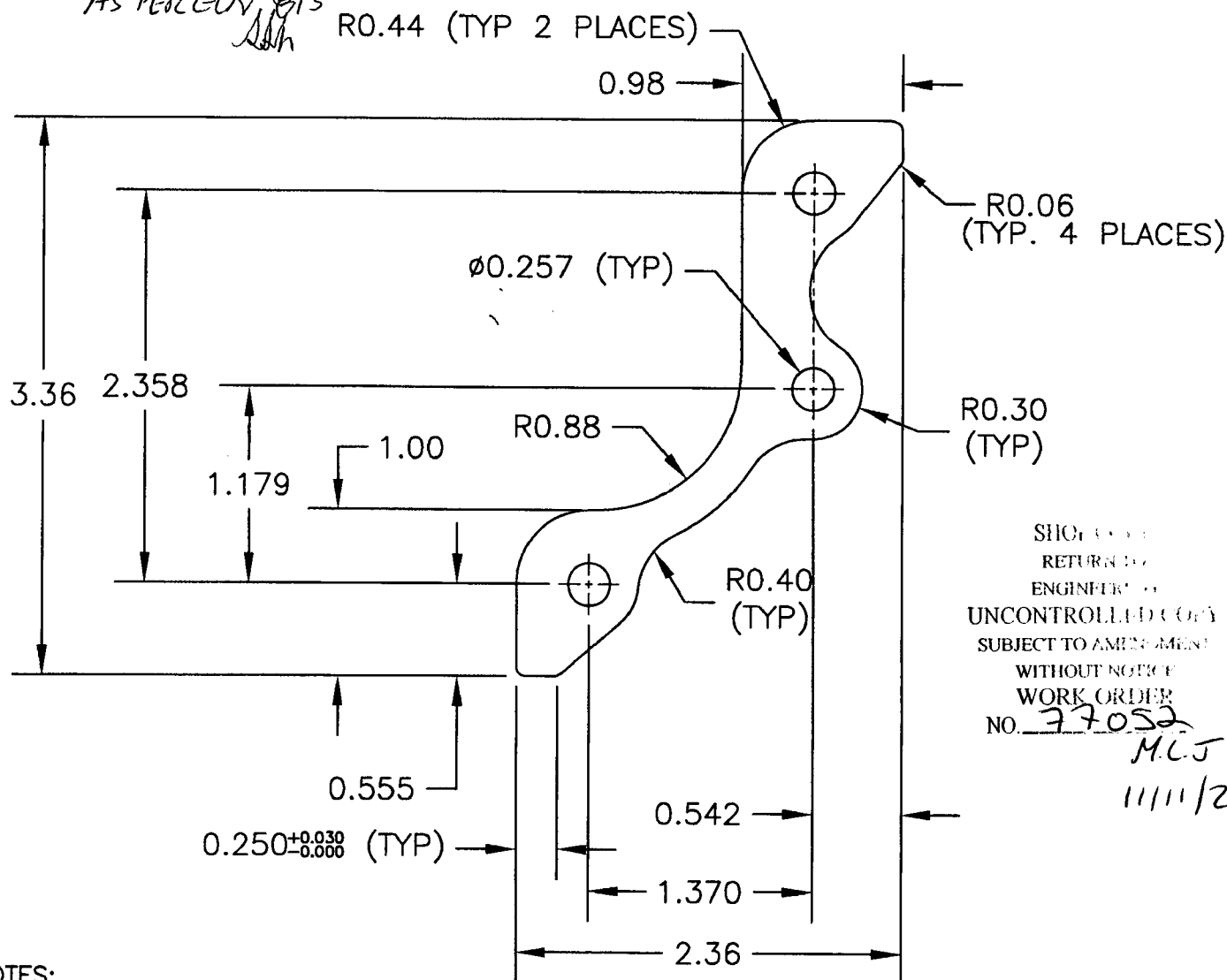
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RELEASED
06.06.21

AS PER ECN 813



SHO 0000
RETURN TO
ENGINEER 00
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77052

M.C.J
11/11/25

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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